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⑤④ **Functionalized polymers.**

⑤⑦ Functionalized polymers manifesting exceptional stress-strain properties are prepared from polyols having terminal and nonterminal hydroxyl groups.

EP 0 502 839 A2

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BACKGROUND OF THE INVENTION1. Field of the Invention

5 The present invention relates to functionalized polymers and, more particularly, to polyurethanes, polyesters and polycarbonates derived from polyols which include both terminal and nonterminal hydroxyl groups.

2. Related Art

10 It is well known in the art to convert olefins to aldehydes having one additional carbon atom by contacting a C₂ to C₂₀ monoolefin or a C₅ to C₅₀₀₀ nonconjugated polyolefin with hydrogen and carbon monoxide in the presence of a catalyst based on cobalt or rhodium metal. See, for example, U. S. Patent 4,871,878.

It is also known, as disclosed in U. S. 3,383,426, to hydroformylate polymers utilizing hydrocarbon-soluble phosphine and phosphite catalyst complexes which include a Group VIII transition metal and at least one ligand consisting of a carbon monoxide molecule.

15 It is also known in the art to prepare polyurethane block polymers by condensing diisocyanates with polyols which have -CH₂OH terminal groups attached to the polymer by way of initiator-transfer agents through dehydrochlorination, hydroboration and oxidation steps. Thus, this process involves creating additional unsaturation in the polymer to be functionalized rather than taking advantage of existing unsaturation. See, for example, J. P. Kennedy, Chemtech, Nov., 694 (1986).

20 Polyols which are presently utilized in the industry to prepare polyurethanes, polycarbonates and polyethers are predominantly polyether and polyester polyols. Such polyols are generated by ethylene oxide and propylene oxide oligomerization reactions, typically utilizing adipic acid. Such polyols therefore contain only terminal hydroxyl groups. None of the polyols presently utilized to prepare polyurethanes have nonterminal -CH₂OH groups and therefore have limited functional density.

SUMMARY OF THE INVENTION

30 The present invention is directed to functionalized polymers characterized by having nonterminal functional groups. As a result, the polymers of the present invention manifest significantly increased stress-strain properties when compared to the prior art polymers.

The present invention is also directed to a method for preparing polyurethanes, polycarbonates and polyesters from reduced aldehyde-functionalized polymers. The aldehyde functionalized polymers are prepared taking advantage of unsaturation already existing in the polymer, i.e., beginning with an olefinic polymer. Such aldehyde-functionalized polymers preferably are prepared by a process comprising mixing an olefinic polymer with hydrogen and carbon monoxide in the presence of a Rhodium I catalyst. Preferably, the olefinic polymer has a weight average molecular weight (Mw) of at least 100 and is selected from the group consisting of olefinic homopolymers and copolymers, and copolymers of olefins and at least one copolymerizable nonolefinic monomer.

40 The Rhodium I catalysts suitable for use in the present invention are utilized at levels of less than 200 parts of catalyst based on metal rhodium per 10⁶ parts of polymer. Thus, the present process can be conducted economically, i.e., at low catalyst cost, and at relatively mild conditions.

The resulting aldehyde-functionalized polymers are then reduced to produce the corresponding polyol characterized by having, per polymer molecule, at least one repeat unit of the formula:



50 wherein A is absent, i.e., where the -CH₂OH group is directly attached to the polymer backbone derived from an unsaturated portion thereof, or represents a radical derived from a pendant unsaturated hydrocarbon portion of a monomer of the polymer molecule which pendant portion has from 1 to about 8 carbon atoms; and B represents hydrogen or, together with A represents a radical derived from a pendant portion of an unsaturated monocyclic, bicyclic or tricyclic hydrocarbon monomer of the polymer molecule and having from about 5 to about 22 carbon atoms. Preferably, A represents a radical derived from a pendant unsaturated portion of a butadiene radical or together with B represents a radical derived from dicyclopentadiene, 5-isopropylidene-2-norbornene,

or 5-ethylidenenorbornene. The polyol is then reacted with 1) a diisocyanate to produce the corresponding polyurethane; 2) a disubstituted carbonate to produce the corresponding polycarbonate; or 3) a dicarboxylic acid or derivative thereof to produce the corresponding polyester.

5 DETAILED DESCRIPTION OF THE INVENTION

As utilized herein, the term "nonterminal" refers to a portion of the polymer backbone other than the terminal ends, for example, where a $-\text{CH}_2\text{OH}$ group is attached to the polymer backbone at a point within the terminal ends thereof or where a $-\text{CH}_2\text{OH}$ group is attached to a radical derived from a pendant unsaturated monomer portion of the polymer molecule within the terminal ends thereof.

A. Hydroformylation

In accordance with the present invention, the polyurethanes and polycarbonates of the present invention are prepared from aldehyde-functionalized polymers which include both terminal and nonterminal aldehyde groups. These aldehyde-functionalized polymers are prepared taking advantage of unsaturation already existing in the polymer.

A preferred method for preparing aldehyde-functionalized polymers useful in preparing the polyol-derived functional polymers of the present invention comprises mixing an olefinic polymer having a weight average molecular weight of at least about 1000 with less than 20 parts of a ligand-modified Rhodium I catalyst per 10^6 parts polymer, and then reacting the resulting mixture with hydrogen and carbon monoxide at a temperature of from about $50-150^\circ\text{C}$, preferably, $80-130^\circ\text{C}$, such as at 100°C , and a total pressure of from 100 psig - 2000 psig, preferably, 500-1500 psig, such as 1000 psig. Another method for preparing aldehyde-functionalized polymers which include terminal and nonterminal functional groups is disclosed in U.S. 3,383,426 and involves hydroformylating a polymer utilizing carbon monoxide and hydrogen in the presence of a phosphine or phosphite catalyst.

Olefinic polymers useful in the process of the present invention are those prepared from monomers represented by the formula $\text{CH}_2=\text{CHR}$ wherein R represents hydrogen and alkyl radicals having from 1 to about 12 carbon atoms which alkyl radicals may be unsaturated, e.g., where the monomer is a diene. Examples of such monomers include ethylene, propylene, 1-butene, 1-pentene, 1-hexene, 2-methyl-1-propene, 3-methyl-1-pentene, 4-methyl-1-pentene, 3,3-dimethyl-1-butene, 2,4,4-trimethyl-1-pentene, 3-methyl-1-hexene, 1,4-ethyl-1-hexene, 1,4-butadiene and the like.

Preferred polyolefins include homopolymers such as polyethylene, polypropylene, polybutylene, polybutadiene, polyoctene; copolymers of olefins such as poly(ethylene propylene), poly(ethylene octene), poly(ethylene isobutylene), poly(ethylene-1-butene), poly(ethylene-hexene), poly(propylene octene); copolymers of olefins and at least one copolymerizable monoolefinic monomer such as poly(ethylene propylene diene monomer), poly(ethylene vinyl acetate), poly(ethylene vinyl alcohol), poly(ethylene ethyl acrylate), poly(propylene methyl acrylate), copolymers of dienes and acrylonitrile such as a copolymer of butadiene and acrylonitrile; and the like.

Especially preferred polyolefins include homopolymers of ethylene, propylene and butadiene; copolymers of ethylene and propylene; copolymers of ethylene and octene, e.g., linear low density polyethylene; copolymers of ethylene and vinyl acetate; copolymers of ethyl and vinyl alcohol which may also contain residual acetate groups; and copolymers of two or more olefins and a diene monomer such as poly(ethylene propylene diene monomer) EPDM. Satisfactory diene monomers include straight chain (acyclic) dienes such as 1,4-hexadiene, 2-methyl-2,4-pentadiene, 1,4,9-decatriene and 11-ethyl-1,11-tridecadiene; monocyclic dienes such as 1,5-cyclooctadiene, dienes such as 5-ethylidenenorbornene (ENB), 5-methylene-2-norbornene; 5-isopropylidene-2-norbornene and 2-methyl-bicyclo-(2.2.1)-2,5-heptadiene; fused ring bicyclics such as bicyclo (4.3.0)-3,7-nonadiene; 5-methyl-bicyclo(4.3.0)-3,7-nonadiene; 5,6-dimethyl-bicyclo-(4.3.0)-3,7-nonadiene and bicyclo(3.2.0)-2,6-heptadiene; alkenyl substituted monocyclics such as 4-vinyl-cyclohexene; 1,2-divinylcyclobutane and 1,2,4-trivinylcyclohexane; and tricyclics such as dicyclopentadiene (DCPD). Grades of EPDM rubbers suitable for use in the practice of the invention are commercially available; Rubber World Blue Book 1975 Edition, *Materials and Compounding Ingredients for Rubber*, pages 406-410. Preferred EPDM rubbers are those marketed by Uniroyal Chemical Company, Inc., Middlebury, CT under the tradename Trilene®, such as Trilene® 66 and 67 (ENB diene monomers), Trilene® 55 and 65 (DCPD diene monomer) and the like. Other preferred EPDM rubbers include those wherein the diene monomer is 5-isopropylidene-2-norbornene. Although not specifically required, the ethylene to propylene ratio in such EPDM rubbers is preferably within a range of from about 40/60 to about 50/50.

In order to undergo the hydroformylation reaction the polyolefin used in the present invention must contain

a level of unsaturation, i.e., as carbon to carbon double bond, which is the site where the syngas will form the aldehyde (-CHO) group. This unsaturation can be present in the backbone of the polymer or in a pendant group thereof, e.g., as in EPDM materials. Preferably the level of unsaturation in the polyolefin will be in the range of from one C=C per polymer chain (or molecule) up to about one C=C per 4 carbon atoms. Procedures for determining the level of unsaturation of polymers are well known. For example, the level of unsaturation can be determined utilizing ASTM D-1638-59T. The level of unsaturation can also be determined utilizing infrared spectroscopy or ^1H nmr. This method can be conducted according to well-known procedures as described in Willard et al, *Instrumental Methods of Analysis*, Chapters 5 and 6, Van Nostrand Co., Inc., Publishers (1965). Alternatively, well-known titration methods can also be utilized. A preferred method for determining unsaturation levels is ^1H nmr.

Suitable olefinic polymers have a weight average molecular weight (Mw) of from about 1000 to about 250,000. Preferred olefinic polymers are those having a Mw of from 600 to about 150,000, most preferably from 900 to about 7,000.

The olefinic polymer is mixed with carbon monoxide and hydrogen, with the polymer in the melt phase or dissolved in an inert solvent. Where no solvent is utilized, the polymer is heated to the Tg value corresponding to the specific polymer and then the carbon monoxide and hydrogen are added thereto and mixed. Where an inert solvent is utilized, the polymer is dissolved in the solvent and then the carbon monoxide and hydrogen are added and mixed. Suitable inert solvents for dissolving the polymer include toluene.

The hydrogen and carbon monoxide are mixed with the polymer in a H_2/CO molar ratio of from about 1:3 to about 3:1, preferably from about 1:2 to about 2:1. A most preferred ratio is 1:1. Throughout the course of the reaction, the presence of H_2 and CO is preferably essentially maintained at the initial molar ratio.

Following addition of carbon monoxide and hydrogen, a suitable catalyst is added to the mixture. Alternatively, the catalyst can be mixed with the polymer prior to addition of the hydrogen and carbon monoxide. Suitable catalysts for hydroformylating the olefinic polymer include dicarbonyl acetylacetonate Rhodium I ($\text{Rh}(\text{CO})_2\text{AcAc}$), cyclooctadiene trifluoroacetyl Rhodium I dimer ($[(\text{Rh}(\text{cod})(\text{O}_2\text{CCF}_3))]_2$), $\text{RhH}(\text{CO})(\text{PPh}_3)_3$. A preferred catalyst is $\text{Rh}(\text{CO})_2\text{AcAc}$.

The components of the mixture are then reacted, at a temperature of from about 50°C to about 225°C and at a pressure greater than about 2.0 MPa, to produce the aldehyde-functionalized polymers.

In the following examples, the EPDM and polybutadiene polymers utilized were purchased. The rhodium hydroformylation catalysts were either purchased or prepared according to known literature procedures. Thus, $\text{Rh}(\text{CO})_2(\text{acetylacetonate})$ and $\text{RhH}(\text{CO})(\text{PPh}_3)_3$ were purchased from Strem Chemicals, Inc., Newburyport, MA 01950. $[\text{Rh}(\text{cod})(\text{O}_2\text{CCF}_3)]$ was synthesized according to the following procedure. $[\text{Rh}(1,5\text{-cyclooctadiene})\text{Cl}]_2$ (made from $\text{RhCl}_3 \cdot 3\text{H}_2\text{O}$ [Englehard Industries, Inc., Newark, NJ] using the preparation described by G. Giordano and R. H. Crabtree found in *Inorg. Synth.*, Vol. 19, 218-220) (0.370gm, 0.751mmol) was placed in a Schlenk tube under Ar atmosphere and dissolved in 25 mL of degassed, dry toluene. AgO_2CCF_3 (0.376gm, 2.3 equiv.) was added to the bright yellow solution and allowed to stir for 2 hours. The solution was then filtered through diatomaceous earth to give a clear, bright yellow solution. The toluene solvent was then removed in vacuo. The yellow solids were then recrystallized by dissolving in 5 mL of CH_2Cl_2 and then adding 5 mL of hexanes. The CH_2Cl_2 was removed in vacuo and the remaining hexane solution was cooled to -78°C in a dry ice/acetone bath to yield a fine yellow powder of the desired product. The bright yellow solid was isolated by filtration and dried in vacuo. The product was then recrystallized a second time by dissolving in CH_2Cl_2 and crystallizing from hexanes as before. The product was then characterized by ^1H nmr and FTIR. Likewise, the ruthenium hydrogenation catalysts were either purchased or prepared according to known literature procedures. Thus, $\text{RuHCl}(\text{CO})(\text{P}(\text{C}_6\text{H}_{11})_3)_2$ was prepared according to the procedure set forth in Moers et al, *Recueil*, 91, 591-600 (1972). $\text{RuCl}_2(\text{CO})_2(\text{PPh}_3)_2$ was purchased from Strem Chemicals.

Example 1

Solution Hydroformylation

In this method a 2-liter autoclave was charged with a specified amount of EPDM polymer (Nordel 1440 EPDM Hydrocarbon purchased from E. I. duPont de Nemours; diene monomer, 1,4-hexadiene; Mw of 290,000; Mooney viscosity of 40; 0.86 specific gravity; 55/39/6.2 Ethylene/Propylene/Diene Monomer weight percent) in solution in toluene and an effective amount of a soluble, ligand-modified metal complex catalyst. The autoclave was pressurized to 1500 psig with CO/H_2 and heated to 100°C . The reaction was continued while maintaining a flow of CO/H_2 to the system to maintain a CO/H_2 molar ratio of about 1:1 and maintain a constant autoclave pressure.

After specified periods of time, the reaction was stopped by venting off the gas and cooling the solution to

28°C. A representative portion of the reaction solution was removed and the polymer contained therein precipitated with methanol. The polymer was then analyzed by IR and ¹H NMR for aldehyde functional groups. The runs were continued by again pressurizing the autoclave to 1500 psig with CO/H₂ and heating to 100°C for additional intervals.

5 In Example 1, a 10 ppm level of dicarbonyl acetylacetonate Rhodium I was used to hydroformylate an EPDM polymer in solution.

The autoclave was charged with:

- 10 grams of EPDM polymer dissolved in 120cc toluene, and,
- 0.1 mg of Rh(CO)₂AcAc

10 and the solution processed in accordance with the procedure set forth above. The reaction was interrupted at 4.5, 12.0 and 20.0 hours and representative samples analyzed by IR and H¹ NMR. The results are tabulated in Table 1.

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TABLE 1
SUMMARY OF EXAMPLE 1

Example	EPDM(G)/ 120cc toluene	Weight (mg) Rh(CO) ₂ AcAc	Conc.*	Time (hrs)	IR	Results H ¹ NMR
Control	10	0	0	15.0	IR shows no aldehyde peak.	H NMR showed no aldehyde.
(1)	10	0.1	10ppm	4.5	IR indicates aldehyde groups to be present.	H NMR indicates aldehyde groups to be present.
				12.0	IR analysis indicates more aldehyde groups were produced.	
				20.0	IR indicated aldehyde by the band at 1732.	H ¹ NMR indicated aldehyde production.

* Concentration of catalyst to polymer.

Example 1 demonstrates that successful solution hydroformylation of an EPDM polymer occurs at catalytic levels as low as 10ppm.

Example 2

5 A toluene solution of EPDM (Ethylene-Propylene-Diene Monomer) polymer was made by dissolving 300.05gm of EPDM polymer (Trilene® 55 obtained from Uniroyal Chemical Co., Middlebury, CT; Ethylene/propylene 48/52; diene monomer-dicyclopentadiene; Mu-6500, and Brookfield viscosity @ 100°C of 67,000) in 500mL of toluene and then degassing the solution by bubbling with argon. In a separate flask, Rh-(acac)(CO)₂ (75.3mg, 0.292 mmol) (acac = acetylacetonate) was dissolved in 100mL of toluene and the solution
10 was degassed by bubbling with argon. Both solutions were placed in a 2L reactor. The solutions were degassed with nitrogen three times in the reactor and then heated to 100°C under 5 psig of nitrogen. The reactor was then charged to 1000 psig with 1:1 H₂/CO. The extent of reaction was measured by gas uptake from a calibrated reservoir. In this way the amount of aldehyde groups placed on the polymer backbone could be measured and
15 controlled. At the desired functionality level, the reaction was stopped by quickly cooling the reactor and venting the H₂/CO gas from the reactor. The polymer solution was then removed from the reactor. The amount of toluene solvent was reduced by rotary evaporation and the hydroformylated polymer was precipitated from the toluene solution by slow addition of methanol (500mL) with stirring. The solvents were then decanted and the polymer redissolved with 500mL of toluene and precipitated again with 500mL of methanol. After decanting the solvents,
20 residual methanol was removed from the polymer by rotary evaporation leaving a light amber toluene solution of purified polyaldehyde. The extent of functionalization could be determined by comparing the integrals for the aldehyde groups and the residual olefin groups on the polymer in the ¹H nmr.

Example 3

25 The EPDM(53.5gm) utilized in Example 2 was dissolved in 90 mL of toluene was placed in a 300mL stainless steel reactor. A solution comprised of Rh(acac)(CO)₂ (5.7mg, 22.09μmol) and RuCl₂(CO)₂(PPh₃)₂ (50.7mg, 67.37μmol) dissolved in 20mL of toluene was added to the reactor. The reactor was degassed three times with nitrogen and then heated to 150°C under 5 psig of nitrogen. The reactor was then charged with 1000 psig of
30 1:1 H₂/CO. Gas uptake was measured from a calibrated reservoir. After 19.5 hours the reaction was stopped by cooling the reactor and venting the H₂/CO gas. The reaction mixture was removed from the reactor and ¹H nmr revealed that 35.3 percent of the starting olefin groups had reacted to form aldehyde groups and 15.5 percent of the starting olefin had reacted to form alcohol groups. 49 percent of the starting olefin was unreacted.

Example 4

35 EPDM-Polyaldehyde was produced using [Rh(cod)(O₂CCF₃)₂](cod = 1,5-cyclooctadiene) as the hydroformylation catalyst. The same procedure described in Example 1 was used except that [Rh(cod)(O₂CCF₃)₂] was substituted for Rh(acac)CO₂. When the same molar concentration of catalyst was used (based on Rh),
40 [Rh(cod)(O₂CCF₃)₂] was found to be just as effective a catalyst for hydroformylation as Rh(acac)(CO)₂.

EXAMPLES 5 TO 15

45 In Examples 5 to 15, hydroformylation of an EPDM polymer (Nordell 1440, described in Example 1) was performed according to the procedure set forth below under conditions which simulate the polymer in a melt phase. This procedure was performed utilizing dicarbonyl acetylacetonate Rhodium (I) and various levels of hydrocarbonyl tris(triphenyl phosphine) Rhodium (I).

Simulated Melt Phase Hydroformylation

50 In this method a stated amount of an EPDM (Nordell 1440) polymer and an effective amount of a specified catalyst were dissolved in toluene in a dry box. The solution was mixed well and the toluene removed by vacuum. A sample of the EPDM/catalyst was placed in a 30 cc Parr reactor in the dry box. The reactor was then heated to the stated temperature (150°C to 215°C) under a CO/H₂ pressure of 1000 psig. The reaction
55 was continued while maintaining a flow of CO/H₂ to the system to maintain a CO/H₂ molar ratio of about 1:1 and a reactor pressure of about 1500 psig. Samples were removed at specified intervals and analyzed by IR and H NMR for aldehyde functional groups. The reaction conditions and results are set forth in Table 2.

TABLE 2
SUMMARY OF EXAMPLES 7 TO 17

EXAMPLE	EPDM(g)	Catalyst/wt(g)	Conc.*	Temp. CO/H ₂ (°C)	Time (min.)	
(5)	0.10	--	0	150.	150.	IR shows no aldehyde peak.
(6)	1.00	--	0	150.	4275	IR shows trace H NMR after peak at 1738. 11709 transients showed no aldehyde. Olefin had isomerized.
(7)	0.10	A	10pph	150.	150.	IR shows aldehyde peak at 1726 and acid peak at 1707.
(8)	0.10	A	10pph	150.	315.	IR shows aldehyde peak at 1730.
(9)	0.10	A	10pph	215.	125.	IR shows aldehyde peak at 1730.
(10)	0.10	B	10pph	150.	360.	IR shows aldehyde peak at 1730 also a peak at 1794 due to the catalyst.

TABLE 2 (Continued)
SUMMARY OF EXAMPLES 5 TO 15

EXAMPLE	EPDM(g)	Catalyst/wt(g)	Conc.* (°C)	Temp. CO/H ₂ (psig)	Time (min.)	
(11)	1.00	A	0.01	1pph 150.	1000.	1110. IR shows aldehyde peak at 1730. H NMR shows no olefin.
(12)	1.00	A	0.001	0.1pph 150.	1000.	1050. IR shows aldehyde peak at 1732. H NMR shows approx. 50% olefin.
(13)	1.00	A	0.0001	100ppm 175.	1000.	1140. IR shows aldehyde peak at 1732. H NMR shows olefin and trace aldehyde.
(14)	1.00	A	0.00001	10ppm 200.	1000.	1080. IR shows trace aldehyde peak at 1732. H NMR after 11294 transients showed trace aldehyde and <90% olefin.
(15)	1.00	A	0.0001	1ppm 200.	1000.	4115. IR shows trace peak at 1740. H NMR after 11004 transients showed no aldehyde. Olefin has isomerized.

Catalyst A: hydrocarbonyl tris(triphenyl phosphine) Rhodium (I)
Catalyst B: dicarbonylacetyl acetate Rhodium (I)
* Concentration of catalyst to polymer.

Examples 5 and 6 demonstrate that the presence of a catalyst is needed to initiate the hydroformylation reaction. Increased temperatures and extended reaction times do not result in the production of aldehyde-functionalized EPDM polymers in the absence of an appropriate catalyst.

Examples 7 through 9 show the successful hydroformylation of EPDM utilizing a 10 pph level of hydrocarbonyl tris(triphenyl phosphine) Rhodium (I). Higher temperatures result in lower reaction times.

Example 10 demonstrates the successful hydroformylation of EPDM utilizing a 10 pph level of dicarbonyl acetylacetonate Rhodium (I).

Examples 11 through 15 show the hydroformylation of EPDM utilizing levels of catalyst as low as 10 ppm. Example 14, in particular, demonstrates the hydroformylation of EPDM containing 10 ppm of hydrocarbonyl tris(triphenyl phosphine) Rhodium I at 200°C and 1000 psig (CO/H₂ 1:1) in the absence of solvent.

Example 16

A toluene solution of polybutadiene polymer (Aldrich Chemicals cat. no. 20050-6; Mn 4500, 45% vinyl, 55% cis and trans-1,4) was made by dissolving 350.70gm of polybutadiene in 600mL of toluene and then degassing the solution by bubbling with argon. In a separate flask, Rh(acac)(CO)₂ (27.0mg, 0.105mmol) (acac=acetylacetonate) was dissolved in 100mL of toluene and the solution was degassed by bubbling with argon. Both solutions were placed in a 2L reactor, the solutions were degassed with nitrogen three times in the reactor and then heated to 100°C under 5 psig of nitrogen. The reactor was then charged to 1000 psig with 1:1 H₂/CO. The extent of reaction was measured by gas uptake from a calibrated reservoir. In this way the amount of aldehyde groups placed on the polymer backbone could be measured and controlled. At the desired functionality level, the reaction was stopped by quickly cooling the reactor and venting the H₂/CO gas from the reactor. The polymer solution was then removed from the reactor. The amount of toluene solvent was reduced by rotary evaporation and the hydroformylated polymer was precipitated from the toluene solution by slow addition of methanol (500mL) with stirring. The solvents were then decanted and the polymer redissolved with 500mL of toluene and precipitated again with 500mL of methanol. After decanting the solvents, residual methanol was removed from the polymer by rotary evaporation leaving a light amber toluene solution of purified polyaldehyde. The extent of functionalization could be determined by comparing the integrals for the aldehyde groups and the residual olefin groups on the polymer in the ¹H NMR.

B. Polyol Preparation

The resulting aldehyde-containing polymers are freed of catalyst by precipitating the polymer from a non-polar solvent, e.g., toluene, utilizing a polar solvent, e.g., methanol. The aldehyde functionalities are then reduced to the corresponding hydroxyl groups utilizing any one of several known suitable reducing agents such as, for example, sodium borohydride and the like. Alternatively, the aldehyde functionalities can be reduced utilizing hydrogen gas and a suitable hydrogenation catalyst, e.g., a ruthenium phosphine catalyst. Suitable hydrogenation catalysts include RuCl₂(CO)₂(PPh₃)₂ and RuHCl(CO)(P(C₆H₁₁)₃)₂.

Following removal of the hydroformylation catalyst and conversion of the aldehyde groups to the corresponding hydroxyl group, the resulting polyols are condensed with 1) an appropriate diisocyanate to produce the corresponding polyurethane; 2) with an appropriate disubstituted carbonate to produce the corresponding polycarbonate; or 3) with an appropriate dicarboxylic acid, or derivative thereof, e.g., the corresponding acid chloride thereof, to produce the corresponding polyester.

Example 17

A toluene solution of the polyaldehyde of Example 2 was reduced in volume on a rotary evaporator and then placed in a silylated 4L glass beaker. 500mL of tetrahydrofuran and 60mL of ethanol were added to the solution. For 0.153mol of aldehyde groups present in the polymer solution, 2.17gm (1.5eq., 0.0574mol) of NaBH₄ were added slowly to the polymer solution. NaBH₄ allowed to react for 18 hours to ensure complete reaction. The reaction was then quenched with 70mL of 1.2M HCl in MeOH. This was allowed to stir for 30 minutes and then the polymer was precipitated with 350mL of MeOH. The solvents were decanted and 250mL of tetrahydrofuran was added to redissolve the polymer. An additional 10mL of 1.2M HCl in MeOH were added to the solution to quench any remaining NaBH₄. The polymer was then precipitated with 350mL of MeOH and the solvents were decanted. The polymer was then poured into a container made from teflon coated foil and dried in a vacuum oven at 40°C for 24 hours. The extent of functionalization could be determined by comparing the integrals for the alcohol groups and the residual olefin groups on the polymer in the ¹H nmr.

Example 18

EPDM-Polyaldehyde was prepared in the same manner as described in Example 2 on a 50gm scale in a 300mL reactor. Upon reaching the desired functionality level, the hydroformylation reaction was stopped by cooling the reactor and venting the H₂/CO. The reactor was then degassed with nitrogen three times. RuHCl(CO) (P(C₆H₁₁)₃)₂ (25mg, 0.0344mmol) dissolved in 10mL of toluene was then injected into the reactor by syringe. The reactor was then heated to 150°C under 5 psig of nitrogen. The reactor was then charged to 1000 psig with H₂ gas and allowed to react. Gas uptake was monitored from a calibrated reservoir. The reaction was stopped after two hours by cooling the reactor and venting the H₂ gas. ¹H nmr revealed that 91.8 percent of the aldehyde groups had been reduced to alcohol groups and the residual olefin, that had not been hydroformylated, was untouched by the Ru catalyst.

Example 19

EPDM-Polyaldehyde was prepared in the same manner as described in Example 2. A 100mL stainless steel reactor was charged with 5gm of EPDM-Polyaldehyde and approximately 45mL of toluene. The reactor was also charged with RuCl₂(CO)₂(PPh₃)₂ (2.2mg, 2.92μmol). The reactor was then flushed with argon three times. The solution was then heated to 150°C under 10psig of argon. The reactor was charged to 300 psig with hydrogen and allowed to react. After 4.5 hours the reaction was stopped by cooling the reactor and venting the hydrogen gas. The reaction mixture was removed and ¹H nmr revealed that 57 percent of the original aldehyde groups had been reduced to alcohol groups. The functionality on the material consisted of 35.8% alcohol groups, 62.4% aldehyde groups, and 1.8% residual olefin groups.

Example 20

The orange-amber, toluene solution of polybutadiene aldehyde of Example 16 was concentrated by rotary evaporation and placed in a 2L beaker. To the polymer solution, 500mL of tetrahydrofuran and 70mL of ethanol were added. NaBH₄ (3.2gm, 0.0846 mol, 1.45 equiv.) was added to the solution in portions. The solution immediately went from orange to bright yellow in color. The solution was left to stir overnight (18hrs). The reaction was then quenched by bringing the solution to acidity with 70mL of 1M HCl in ethanol. The polymer was then precipitated from solution with 500mL of methanol. After decanting the solvents, the polymer was redissolved with 500mL of tetrahydrofuran. The polymer solution was then reacidified with 10mL of 1M HCl in ethanol and the polymer was precipitated with 500mL of methanol. After the solvents were decanted the polymer was redissolved in 500mL of toluene and residual methanol was removed by rotary evaporation. To further remove salts, the polymer solution was centrifuged and the polymer solution was decanted from the salts. The polymer was then precipitated from solution with 500mL of methanol and solvents were decanted off. The remainder of the solvents were removed in vacuo to yield the neat material.

C. Polyurethane Preparation

The polyurethanes of the present invention are prepared through stepwise polymerization (or step-reaction polymerization) to produce condensation polymers. The reaction can be represented by the following scheme:

$$\text{XHOROH} + \text{YOCNR}'\text{CNO} \rightarrow [\text{OROC(O)NHR}'\text{NHC(O)}]_2$$

Preferred polyols for use in preparing polyurethanes of the present invention are the products of hydroformylated and reduced polybutadiene and EPDM materials which materials, prior to hydroformylation, have a weight average molecular weight (Mw) of from about 600 to about 250,000.

Suitable diisocyanates include 2,4-toluenediisocyanate, 4,4'-benzidenediisocyanate, 1,5-naphthalene diisocyanate, diphenylmethane-diisocyanate and 4,4'-methylene bis(cyclohexylisocyanate). Preferred diisocyanates are diphenylmethane diisocyanate and 4,4'-methylene bis (cyclohexylisocyanate) both of which are commercially available from MoBay Chemical Company, Houston, Texas. The most preferred diisocyanate is 4,4'-methylene bis(cyclohexyl isocyanate).

The stepwise polymerization is conducted at a suitable temperature in an inert solvent and in the presence of a suitable catalyst. A preferred solvent is m-xylene. Suitable polymerization catalysts are well known in the art, e.g., dialkyltin dicarboxylates. A preferred catalyst is dibutyltin dilaurate which is commercially available from Alfa Products, Danvers, MA 01923.

A suitable temperature can range from about 25°C to about 150°C, preferably from about 50°C to about 100°C. A most preferred temperature is 80°C.

Depending on the particular application of the polyurethane to be prepared, certain additives and auxiliary

materials may be utilized. For example, flame retardant additives, antiaging additives, pigments, fillers and the like may be utilized to provide the polyurethanes with additional desired characteristics. In addition, cross-linking agents and/or chain extenders may be utilized to influence the end properties of the polyurethane, in particular the hard segment/soft segment relation. For example, to prepare elastomeric polyurethanes for use in film applications, a chain extender such as 1,4-butanediol can be utilized. For examples of suitable additives and auxiliary agents, see generally, Polyurethane Handbook, Ed. G. Oertel, Hanser Publishers, New York, distributed by Macmillan Publishing Company, New York, which is incorporated herein by reference.

Example 21

Polyurethane films were prepared, according to the following procedure, and the stress-strain and hardness properties were determined. Polyols were prepared according to the procedure of Example 17. Polyol A had an equivalent weight of 1351 and Fn of 3.7. Fn as utilized herein refers to the number average functionality and is determined, according to ASTM E-222-73 Method B (reflux method), by acetylating the polyol utilizing a solution of acetic anhydride and perchloric acid in 1,2-dichloroethane. The number average functionality can also be determined utilizing ASTM-E-222-73 Method C. Polyols B, C, D and E had equivalent weights of 2000, 1000, 1667 and 1282, respectively, and an Fn of 2.5, 5.0, 3.0 and 3.9, respectively. The 1,4-butanediol was obtained from GAF Corporation and was dried over 4Å molecular sieves. The 4,4'-methylene bis(cyclohexylisocyanate) was obtained from Mobay Chemical Co. (sold as Desmodur W) and was used as received. The isocyanate number was determined by the di-n-butyl amine method (ASTM D-1638-74).

In each case, the quantities of components are listed in Table 3. The indicated amount of the isocyanate was dissolved in 50 ml of m-xylene 24 hours prior to use. This solution was added to a solution of the indicated amounts of polyol, 1,4-butanediol and dibutyltin dilaurate in 50 ml of m-xylene. (The dibutyltin dilaurate catalyst was added to the polyol/butanediol solution after complete dissolution of the polyol and butanediol.) The polyol/isocyanate solution was then vigorously mixed at room temperature for about one minute. The solution was then poured into a teflon lined pan with dimensions 5.5 x 3.9 x .04 inches and placed in a vacuum oven at 50°C for 16 hours. The samples were then removed from the vacuum oven and placed into a standard oven at 95°C for 10-12 hours. The thickness of the film varied from about 0.01 to about 0.025 inches, depending on the percent solids of the polymer solution. The chemical structure of the films was studied by IR spectroscopy. In all cases, a strong carbonyl urethane group absorption at 1720 cm⁻¹ was observed. The isocyanate adsorption at 2270 cm⁻¹ was not observed or was very weak, indicating that there was an essentially complete reaction. The stress-strain properties were measured according to ASTM D-410 (utilizing a Universal Instron Tester) and the hardness (Shore A) was measured according to ASTM D-2240. Results are reported in Table 3.

TABLE 3

Entry No.	Polyol (wt.%) ^a	wt.% Butanediol	wt.% Catalyst	wt.% Diisocyanate	% Solids	Ultimate Strength (psi)	Elongation at Break (%)	Hardness (Shore A)	Modulus (psi) 100%/200%
1	A(2.7)	-	0.03	0.3	6.4	327	436	48	33/41
2	A(2.7) ^b	0.1	0.06	0.5	7.1	1249	269	72	351/396
3	A(2.7)	0.2	0.09	0.8	7.8	1434	190	78	634/729
4	B(3.0) ^b	0.1	0.03	0.4	6.6	666	179	69	-
5	B(1.5)	0.1	0.09	0.4	7.0	1028	615	70	-
6	B(3.4)	-	0.03	0.2	7.1	220	331	62	-
7	B(1.5)	0.04	0.06	0.2	3.1	666	179	69	-
8	B(1.4)	0.06	0.03	0.3	-	890	259	69	-
9	C(1.6)	0.4	0.05	0.3	3.8	1859	397	-	375/371
10	D(2.9)	-	0.03	0.2	6.2	378	275	-	116/120
11	D(4.7)	0.1	0.06	0.8	8.7	513	209	-	220/217
12	D(4.0)	0.2	0.08	1.0	8.1	1278	190	-	636/-
13	D(3.6)	0.3	0.09	1.2	8.4	2332	166	-	1279/-
14	E(3.1)	-	0.03	0.3	6.8	353	339	-	78/84
15	E(3.1)	0.1	0.06	0.6	7.3	1415	385	-	303/302
16	E(3.0)	0.2	0.08	0.9	7.9	2528	299	-	791/699
17	E(3.0)	0.3	0.09	1.1	8.2	2688	179	-	1244/-

^a wt.% is expressed as the percent by weight based on the total weight of the formulation.

^b Contains 0.76 wt.% PTMO-2000, a poly(oxytetramethylene)glycol (GW of 1000, Pn=2) obtained from E. I. duPont de Nemours.

Comparative Example

Following the procedure set forth in Example 20, polyurethane films were prepared from commercially available polyols and the stress-strain and hardness properties were determined. In each case, the quantities of components are listed in Table 4. The chemical structure of the films and the stress-strain and hardness properties were determined as in Example 20.

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TABLE 4

Entry No.	Polyol (wt.%)	Wt.% Butanediol	Wt.% Catalyst	Wt.% Diisocyanate	Wt.% Solids	Ultimate Strength (psi)	Elongation at Break (%)	Hardness (Shore A)	Modulus (psi) 100%/200%
1	H ^a (3.0)	-	0.03	0.3	6.6	310	150	-	-
2	H(2.7)	0.1	0.06	0.6	7.3	425	238	65	149/89
3	I ^b (1.5)	0.1	0.03	0.4	6.7	587	1092	64	-
4	I(3.0)	0.3	0.08	1.2	7.9	4589	408	-	520/597

^a Polyol H is a polyol butadiene resin (EW 1203.9, Fn=2.3) purchased from Sartomer Chemical as R-45HT.

^b Polyol I is a poly(oxytetramethylene)glycol (EW 1000, Fn=2) purchased from DuPont as PTHO-2000.

Example 22

Polyurethane films were prepared, according to the procedure of Example 21, and the stress-strain and hardness properties were determined. The polyols were prepared according to the procedure of Example 20. Polyol J had an equivalent weight of 1496 and Fn of 1.6. Polyol K had an equivalent weight of 566 and Fn of 4.2. In each case, the quantities of components are listed in Table 5 along with the stress-strain and hardness properties.

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TABLE 5

Entry No.	Polyol (wt.%) ^a	Wt.% Butanediol	Wt.% Catalyst	Wt.% Diisocyanate	% Solids	Ultimate Strength (psi)	Elongation at Break (%)	Hardness (Shore A)	Modulus (psi) 100%/200%
1	J(3.4)	0.2	0.12	0.7	7.9	619	97	75	-
2	J(3.4)	0.2	0.15	0.9	8.5	758	174	82	-
3	J(3.5)	0.3	0.18	1.3	9.4	1238	154	86	-
4	K(3.4)	-	0.06	0.8	8.0	662	226	82	-
5	K(3.6)	0.3	0.12	1.7	10.0	1699	125	95	-
6	K(3.5)	0.6	0.15	2.5	11.3	2332	180	98	-
7	K(3.5)	0.8	0.18	3.3	12.4	2477	108	99	-

^a Wt.% is expressed as the percent by weight based on the total weight of the formulation.

D. Polycarbonate Preparation

Polycarbonates can be prepared by reacting, in a suitable solvent, the above-described polyols with a disubstituted carbonate, e.g., diphenyl carbonate, in the presence of a suitable catalyst, e.g., dibutyltin dilaurate. The reaction is conducted at a temperature of from about 100°C to about 250°C, preferably at a temperature of from about 190°C to about 230°C. Suitable solvents include toluene, benzene, meta-xylene, chloroform, ortho-dichlorobenzene, chloroform, heptane, tetrahydrofuran and the like. Suitable catalysts include dialkyltin dicarboxylates, e.g., dibutyltin dilaurate; amines, e.g., tetramethylbutane diamine and 1,4-diaza(2,2,2)bicyclooctane; certain other organic metal compounds, e.g., tin octoate; and certain phosphorous compounds such as phospholine oxide and the like. Mixtures of such catalysts can also be utilized. Disubstituted carbonates suitable for use in the present invention include diphenyl carbonate, dialkylcarbonates such as dimethylcarbonate, and the like. Such polycarbonates can also contain certain additives and auxiliary materials as described above.

Example 23

1.3 gm of EPDM polyol (5000Mw, 3.0 hydroxyl groups/chain, 0.8mmol hydroxyl groups) was dissolved in 10mL of tetrahydrofuran in a 100 mL round bottom flask. 100 mg (0.47mmol) of diphenyl carbonate and 20 mg (0.03mmol) of dibutyltin dilaurate was added to the solution. The solvents were then removed in vacuo and the neat polymer solution was heated to 200°C for 2 hours under an argon atmosphere. The new material, which had a foamlke structure was washed with tetrahydrofuran and dried in vacuo. FTIR of the new polymer lacked the absorbances for the hydroxyl groups present in the starting polymer and displayed the absorbance characteristic for an alkyl carbonate polymer at 1763cm⁻¹.

Example 24

2.0 gm of EPDM polyol (5000Mw, 3.0 hydroxyl groups/chain, 1.2mmol hydroxyl groups) was dissolved in 30 mL of tetrahydrofuran in a 100 mL round bottom flask. 128 mg (0.60mmol) of diphenyl carbonate and 4mg (0.038mmol) of sodium carbonate was added to the solution. The solvent was removed in vacuo and the polymer mixture was heated to 220°C under an argon stream for 2 hours. The cross-linked material was then washed with tetrahydrofuran and dried in vacuo. FTIR of the new polymer lacked the absorbances for the hydroxyl groups present in the starting polymer and displayed the absorbance characteristic for an alkyl carbonate polymer at 1763 cm⁻¹.

E. Polyester Preparation

Polyesters can be prepared by reacting, in a suitable solvent, the above-described polyols with a dicarboxylic acid, and derivatives thereof such as acid chlorides and anhydrides, e.g., methyl terephthalate and phthalic anhydride, in the presence of a suitable catalyst, e.g., triethylamine. The reaction is conducted at a temperature of from about -30°C to about 230°C, preferably from about 30°C to about 230°C. Suitable solvents include toluene, benzene, meta-xylene, chloroform, ortho-dichlorobenzene, chloroform, heptane, tetrahydrofuran and the like. Suitable catalysts include a variety of acids, bases and transition metal complexes. Examples of suitable bases include triethylamine, pyridine, 1,1'-carbonyldiimidazole as well as other known tertiary amine bases. Examples of suitable acids include p-toluenesulfonic acid and the like. Examples of transition metal complexes include tin compounds such as Sn(CO₂)₂, (Butyl)₂SnO and titanium or zirconium alkoxides, for example, Ti(O-n-butyl)₄. Suitable dicarboxylic acids include methyl terephthalate, terephthalic acid, adipic acid and the like, including the acid chloride derivatives thereof. Suitable anhydrides include phthalic anhydride, maleic anhydride, succinic anhydride and malonic anhydride. Polyesters as described can also contain additives and auxiliary materials as described above.

Example 25

1.15 gm of EPDM polyol (5000)Mw, 3.0 hydroxyl groups/chain, 0.704 mmol hydroxyl groups) was dissolved in 10 mL of toluene in a 100 mL round bottom flask. In a separate 100 mL round bottom flask, 0.5 equivalents of terephthaloyl chloride (0.082 gm, 0.4 mmol) were weighed out and dissolved in 10 mL of toluene. 0.1 mL of triethylamine were added to the polymer solution. The terephthaloyl chloride solution was slowly added to the polymer solution with rapid stirring. The solution became cloudy. The flask was fitted with a condenser and a nitrogen bubbler. The solution was heated to reflux and allowed to reflux for 10 minutes then cooled to room

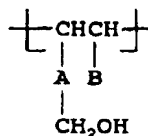
temperature. Solvents were removed in vacuo. The cross-linked, rubbery material was washed with toluene. FTIR of the neat material shows peaks at 1781 cm^{-1} and 1728 cm^{-1} corresponding to the ester groups of an alkyl polyester. No peaks above 3100 cm^{-1} were present to indicate unreacted hydroxyl groups were left.

Example 26

1.06 gm of EPDM polyol (5000Mw, 3.0 hydroxyl groups/chain, 0.649 mmol hydroxyl groups) was dissolved in 10 mL of tetrahydrofuran in a 100 mL round bottom flask. In a separate 100 mL round bottom flask, 0.5 equivalents of terephthaloyl chloride (0.066 gm, 0.324 mmol) were weighed out and dissolved in 10 mL of tetrahydrofuran. 0.053 mL of pyridine (0.65 mmol) were added to the polymer solution. The terephthaloyl chloride solution was slowly added to the polymer solution with rapid stirring. The solution became cloudy. The flask was fitted with a condenser and a nitrogen bubbler. The solution was heated to reflux and allowed to reflux for 1 hour then cooled to room temperature. Solvents were removed in vacuo. The cross-linked, rubbery material was washed with tetrahydrofuran. FTIR of the neat material shows peaks at 1778 cm^{-1} and 1728 cm^{-1} corresponding to the ester groups of an alkyl polyester. No peaks above 3100 cm^{-1} were present to indicate unreacted hydroxyl groups were left.

Claims

1. Composition comprising a functionalized polymer derived from a polyol having, per polymer molecule, at least one repeat unit of the formula:



wherein A is absent or represents a radical derived from a pendant unsaturated hydrocarbon portion of a monomer of the polymer molecule and B represents hydrogen or together with A represents a radical derived from a pendant portion of an unsaturated monocyclic, bicyclic or tricyclic hydrocarbon, said polyol having been reacted, in the presence of a suitable catalyst, with a member of the group consisting of diisocyanates, dicarbonates and dicarboxylic acids and derivatives, including mixtures thereof, under suitable reaction conditions to produce said functionalized polymer.

2. Composition of Claim 1 wherein A represents a pendant hydrocarbon portion of a monomer of the polymer molecule and B represents hydrogen.
3. Composition of Claim 1 wherein A is absent and B is hydrogen.
4. Composition of Claim 2 wherein said pendant hydrocarbon portion of the polymer is a pendant group having from 2 to about 8 carbon atoms.
5. Composition of Claim 1 wherein B, together with A, represents a pendant portion of a radical selected from the group consisting of ethylnorbornane, dicyclopentane, cyclooctane, 5-ethylnorbornane, 5-methylnorbornane, 5-isopropylnorbornane, 2-methyl-bicyclo(4.3.0)nonane, 5-methyl-bicyclo(4.3.0)nonane, 5,6-dimethyl-bicyclo(4.3.0)nonane, and bicyclo(3.2.0)heptane.
6. Composition of Claim 1 wherein the polyol is reacted with a diisocyanate.
7. Composition of Claim 6 wherein said diisocyanate is selected from the group consisting of toluene-diisocyanate, 4,4-benzidenediisocyanate, 1,5-naphthalenediisocyanate, diphenylmethane-diisocyanate, 4,4'-methylene bis(cyclohexylisocyanate).
8. Composition of Claim 1 wherein the polyol is reacted with a disubstituted carbonate.
9. Composition of Claim 8 wherein said disubstituted carbonate is selected from the group consisting of

diphenyl carbonate and dimethyl carbonate.

10. Composition of Claim 1 wherein the polyol is reacted with a dicarboxylic acid.

11. Composition of Claim 10 wherein said dicarboxylic acid is selected from the group consisting of terephthalic acid, adipic acid, methyl terephthalate, including the corresponding acid chloride derivatives thereof, phthalic anhydride, maleic anhydride, succinic anhydride and malonic anhydride.

12. Composition comprising an adduct obtained by sequentially hydroformylating an olefinic polymer under conditions which produce an aldehyde-containing polymer essentially free of hydroxyl groups, then subjecting said aldehyde-functionalized polymer to reduction conditions to produce a polyol, and then reacting said polyol under suitable reaction conditions with a member of the group consisting of diisocyanates, dicarbonates, dicarboxylic acids including acid chloride derivatives thereof, and mixtures thereof.

13. Composition of Claim 12 wherein the polyol is reacted with a diisocyanate.

14. Composition of Claim 13 wherein said diisocyanate is selected from the group consisting of toluenediisocyanate, 4,4'-benzidenediisocyanate, 1,5-naphthalenediisocyanate, diphenylmethane-diisocyanate, 4,4'-methylene bis(cyclohexylisocyanate).

15. Composition of Claim 12 wherein the polyol is reacted with a disubstituted carbonate.

16. Composition of Claim 15 wherein said disubstituted carbonate is selected from the group consisting of diphenyl carbonate and dimethyl carbonate.

17. Composition of Claim 12 wherein the polyol is reacted with a dicarboxylic acid.

18. Composition of Claim 17 wherein said dicarboxylic acid is selected from the group consisting of terephthalic acid, adipic acid, methyl terephthalate, including the corresponding acid chloride derivatives thereof, phthalic anhydride, maleic anhydride, succinic anhydride and malonic anhydride.

19. Method of preparing functionalized polymers comprising the steps of hydroformylating an olefinic polymer under conditions which produce an aldehyde-containing polymer essentially free of hydroxyl groups, then subjecting said aldehyde-functionalized polymer to reduction conditions to produce a polyol, and then reacting said polyol under suitable reaction conditions with a member of the group consisting of diisocyanates, dicarbonates, dicarboxylic acids including acid chloride derivatives thereof, and mixtures thereof.

20. Composition of Claim 19 wherein the polyol is reacted with a diisocyanate.

21. Composition of Claim 20 wherein said diisocyanate is selected from the group consisting of toluenediisocyanate, 4,4'-benzidenediisocyanate, 1,5-naphthalenediisocyanate, diphenylmethane-diisocyanate, 4,4'-methylene bis(cyclohexylisocyanate).

22. Composition of Claim 19 wherein the polyol is reacted with a disubstituted carbonate.

23. Composition of Claim 22 wherein said disubstituted carbonate is selected from the group consisting of diphenyl carbonate and dimethyl carbonate.

24. Composition of Claim 19 wherein the polyol is reacted with a dicarboxylic acid.

25. Composition of Claim 24 wherein said dicarboxylic acid is selected from the group consisting of terephthalic acid, adipic acid, methyl terephthalate, including the corresponding acid chloride derivatives thereof, phthalic anhydride, maleic anhydride, succinic anhydride and malonic anhydride.